





Work Order ID 56232

Wednesday, February 17, 2010 10:06:29 AM




Page 1


Item ID: D412-769-011 Accept  Setup Start 
Revision ID: Stop 
Item Name: Aft Facing Seats (LH/RH)
Start Date: 2/18/2010 Start Qty: 1.00  Cust Item ID:
Required Date: 3/3/2010 Req'd Qty: 1.00  Customer:
Reference:


Approvals: Process Plan: MF Date: 10-2-17 Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN D412-769	Rev B

100	DOCUMENT CONTROL	0.00							
	DC								
Document Control	Memo	0.00							
	Photocopy bluefile & type labels per PPP D412-769-011	CHG 001							

110	QC4- 100% Inspect kits for completeness	0.00							
	QC								
Quality Control	Memo	0.00							

120	Packaging	0.00							
	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D412-769-011	Location: <u>114</u>	PPP Rev: <u>C</u>						

Handwritten: BG 10/06/07

Handwritten: 8/10/06/07

Handwritten: 7/1

Handwritten: 10-6-8 SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56232

Wednesday, February 17, 2010 10:06:29 AM

Page 2

Item ID: D412-769-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Facing Seats (LH/RH)

Start Date: 2/18/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 3/3/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/06/08
K10-6-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, February 17, 2010 10:06:28 AM

Page 1

Work Order ID: 56232



Parent Item: D412-769-011



Parent Item Name: Aft Facing Seats (LH/RH)

Start Date: 2/18/2010

Required Date: 3/3/2010

Comments: IPP rev A 08-07-17 new issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D412-769-041 	CHL7001	Manufactured	No			110	Each	0.0000	1.0000 			
Aft Facing Seat, LH												
D412-769-042 	CHL7002	Manufactured	No			110	Each	0.0000	1.0000 			
Aft Facing Seat, RH												

B56234 10-6-78

B56236 10-6-78

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

25.9 Parts List

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1	1	D412-724-041	HEAD REST ASSY, CENTER
	1	1	D3303-041	HEAD REST
	1	1	D3304-041	TUBE ASSEMBLY
	4	4	AN525-10R6	SCREW
	1		D412-724-043	HEAD REST ASSY, LH
	1		D3303-041	HEAD REST
	1		D3304-043	TUBE ASSEMBLY
	4		AN525-10R6	SCREW
		1	D412-724-044	HEAD REST ASSY, RH
		1	D3303-041	HEAD REST
		1	D3304-044	TUBE ASSEMBLY
		4	AN525-10R6	SCREW
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	2	2	D3782-045	BACK LEG ASSEMBLY
	1	1	D3772-1	BACK LEG
	1	1	D3786-1	SLEEVE
	1	1	D3787-1	FOOT
	1	1	D3764-1	BACK LEG ADAPTER
	1	1	D3773-041	HEAD REST ADAPTER
	1	1	AN5-15A	BOLT
	1	1	AN45-15A	EYE BOLT
	1	1	AN5-17A	BOLT
	2	2	AN4-15A	BOLT
	4	4	NAS1149D0463J	WASHER
	5	5	NAS1149D0568J	WASHER
	2	2	MS21042L4	NUT
	3	3	MS21042L5	NUT
	1	1	D3782-041	FRONT INBOARD LEG ASSEMBLY
	1	1	D3768-1	FRONT INBOARD LEG
	1	1	D3762-041	FRONT LEG FITTING ASSY
	1	1	D3787-1	FOOT
	1	1	AN5-13A	BOLT
	3	3	NAS1149D0568J	WASHER
	2	2	MS21042L5	NUT
	1	1	AN45-13A	EYE BOLT
	1		D3782-043	FRONT OUTBOARD LEG ASSEMBLY, LH
	1		D3768-3	FRONT OUTBOARD LEG, LH
	1		D3762-041	FRONT LEG FITTING ASSY
	1		D3787-1	FOOT
	2		AN45-13A	EYE BOLT
	2		NAS1149D0568J	WASHER
	2		MS21042L5	NUT

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25-00-00

Revision: 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -011	Qty -041	Qty -042	Part Number	Description
		1	D3782-044	FRONT OUTBOARD LEG ASSEMBLY, RH
		1	D3768-4	FRONT OUTBOARD LEG, RH
		1	D3762-041	FRONT LEG FITTING
		1	D3787-1	FOOT
		2	AN45-13A	EYE BOLT
		2	NAS1149D0568J	WASHER
		2	MS21042L5	NUT
1	1	1	D3783-041	LATERAL BRACE ASSEMBLY
1	1	1	D3769-1	TUBE
2	2	2	D3765-1	CLEVIS
2	2	2	AN5-13A	BOLT
4	4	4	NAS1149D0568J	WASHER
2	2	2	MS21042L5	NUT
2	2	2	D3783-043	LONGITUDINAL BRACE ASSEMBLY
1	1	1	D3769-3	TUBE
1	1	1	D3765-1	CLEVIS
1	1	1	AN5-13A	BOLT
2	2	2	NAS1149D0568J	WASHER
1	1	1	MS21042L5	NUT
1	1	1	D3783-045	ANGLE BRACE ASSEMBLY
1	1	1	D3769-5	TUBE
2	2	2	D3765-1	CLEVIS
2	2	2	AN5-13A	BOLT
4	4	4	NAS1149D0568J	WASHER
2	2	2	MS21042L5	NUT
1	1	1	D3784-041	SEAT SUPPORT ASSEMBLY
1	1	1	D3770-1	TUBE
1	1	1	D3763-041	END FITTING ASSY
1	1	1	D3763-045	END FITTING ASSY
2	2	2	AN525-10R20	SCREW
4	4	4	NAS1149D0332J	WASHER
2	2	2	MS21042L3	NUT
1	1	1	D3784-043	SEAT SUPPORT, LH
1	1	1	D3762-043	END FITTING ASSY, LH
1	1	1	D3770-1	TUBE
1	1	1	D3770-3	TUBE
2	2	2	D3763-041	END FITTING ASSY
4	4	4	AN525-10R20	SCREW
4	4	4	NAS1149D0332J	WASHER
4	4	4	MS21042L3	NUT
1	1	1	D3784-044	SEAT SUPPORT, RH
1	1	1	D3762-044	END FITTING ASSY, RH
1	1	1	D3770-1	TUBE
1	1	1	D3770-3	TUBE
2	2	2	D3763-041	END FITTING ASSY
4	4	4	AN525-10R20	SCREW
4	4	4	MS21042L3	NUT
8	8	8	NAS1149D0332J	WASHER

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -011	Qty -041	Qty -042	Part Number	Description
	1		D3766-1	FRONT RAIL, LH
		1	D3766-2	FRONT RAIL, RH
	1	1	D3766-3	REAR RAIL
	1	1	D3767-1	UPPER RAIL
	1	1	AN45-13A	EYE BOLT
	6	6	AN5-10A	BOLT
	2	2	AN5-13A	BOLT
	20	20	NAS1149D0568J	WASHER
	4	4	NAS1149D0463J	WASHER
	12	12	MS21042L5	NUT
	2	2	MS21042L4	NUT
	28	28	MS21042L3	NUT
	2	2	AN4-15A	BOLT
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH
	1	1	D3774-1	SEAT BOTTOM
	1	1	D3774-3	SEAT BACK
	13	13	AN525-10R22	SCREW
	9	9	AN525-10R24	SCREW
	21	21	NAS1149D0363J	WASHER
	13	13	NAS1149D0332J	WASHER
	6	6	AN3-5A	BOLT
	2	2	D3775-1	GUARD
	3	3	D3792.1	SEAT BELT EYE BOLT

NOTE: PART INCLUDED WITH ASSEMBLY ABOVE
PART INCLUDED WITH ASSEMBLY ABOVE
PART INCLUDED WITH ASSEMBLY ABOVE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

IIN-D412-769

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4. WEIGHT AND BALANCE

The following is the weight increase associated with the D412-769-XXX Kits. The installer is responsible for the weight of the equipment coming out of the helicopter in order to install the D412-769-XXX Aft Facing Seat kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D412-769-011 Aft Facing Seat kit	60.0 lb 27.2 kg	0.0 in 0.0 m	0.00 in-lb 0.00 m-kg	87.0 in 2.21 m	5220 in-lb 60.11 m-kg
D412-769-041 Aft Facing Seat, LH (normal position)	30.0 lb 13.6 kg	-16.1 in -0.41 m	-483.0 in-lb -5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (normal position)	30.0 lb 13.6 kg	+16.1 in +0.41 m	+483.0 in-lb +5.58 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (center position)	30.0 lb 13.6 kg	-1.1 in -0.03 m	-33.0 in-lb -0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (center position)	30.0 lb 13.6 kg	+1.1 in +0.03 m	+33.0 in-lb +0.41 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-041 Aft Facing Seat, LH (right Position)	30.0 lb 13.6 kg	+13.9 in +0.35 m	+417.0 in-lb +4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg
D412-769-042 Aft Facing Seat, RH (left Position)	30.0 lb 13.6 kg	-13.9 in -0.35 m	-417.0 in-lb -4.76 m-kg	87.0 in 2.21 m	2610 in-lb 30.06 m-kg

5. PARTS LIST

Qty -011	Qty -041	Qty -042	Part Number	Description
X			D412-769-011	AFT FACING SEAT KIT
1	X		D412-769-041	AFT FACING SEAT, LH
1		X	D412-769-042	AFT FACING SEAT, RH
	1		D412-769-043	AFT FACING SEAT ASSEMBLY, LH
		1	D412-769-044	AFT FACING SEAT ASSEMBLY, RH
	1	1	D412-724-041	HEAD REST ASSEMBLY, CENTER
	1		D412-724-043	HEAD REST ASSEMBLY, LH
		1	D412-724-044	HEAD REST ASSEMBLY, RH

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Revision: C

Date: 09.11.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries